

Date: Monday, 29/09/2008 8:29:23 AM
User: Jean-Luc Menard

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FLOAT WEB
Job Number	: 42314		
Estimate Number	: 10791		
P.O. Number	:	Part Number	: D3282041
This Issue	: 29/09/2008 S.O. No. :	Drawing Number	: D3282 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 11 Type : SKIDTUBES	Drawing Revision	: C
Previous Run	: 42213	Material	:
Written By	: <u>29.09.29</u>	Due Date	: 06/10/2008
Checked & Approved By	:	Qty:	10 Um: Each
Comment	: Est Rev:B 05.09.23 Procedure change KJ/JLM		

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2792130 EXTRUSION



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2792-130 Extrusion 33518

Identify as D3282-1

RT. 08-09-29

2.0 SKIDTUBES 1 SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Cut to length as per Dwg D3282.

2- inspect for surface damage as per QSI0018

RT 08-09-29

(10)

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per Folio FA579 & Dwg D3282

2-Deburr

mk 08/09/29 / ST 05/09/30

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

mk 08/01/29 / ST 05/09/30 (10)

(P10)

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Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

JL 08/10/09

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



ALM 8-10-3



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

③ M 8-10-3

8.0

D32831

Doubler



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3283-1

Doubler

B39162

B42347

M 8-10-10

9.0

MS20470AD47

Rivet, Universal Head



Comment: Qty.: 57.0000 Each(s)/Unit Total: 570.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

57 MS20470AD4-7

Rivet

M127242

SL 8-10-12

10.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install doublers as per Dwg D3282. Apply LPS-3 between doublers and web
ARN/LPS-3 M103674

SL 8-10-12

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/10/14 XB

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Drawing Name: FLOAT WEB

Job Number: 42314

Part Number: D3282041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: L.G.

U 8-10-10

(2)

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/10/15

Job Completion



MF 08-10-15



DESIGN	CP	DRAWN BY	CP	DART AEROSPACE USA, INC.
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	PORT HADLOCK, WA
DATE	05.08.09	DRAWING NO.	D3282	REV. C
		TITLE	FLOAT WEB, 206L/407	SHEET 2 OF 2
		SCALE	1:20	

SECTION B-B

D3283-1
DOUBLER
(REF)

1.970
(REF)

D2792-130
EXTRUSION
(REF)

SECTION A-A

R0.250
(TYP)

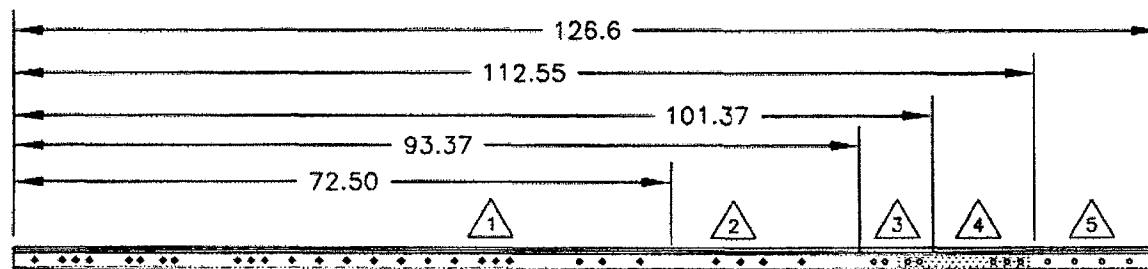
0.05
(TYP)

2.38

D2792-130
EXTRUSION
(REF)

D3282-1 MACHINING NOTES

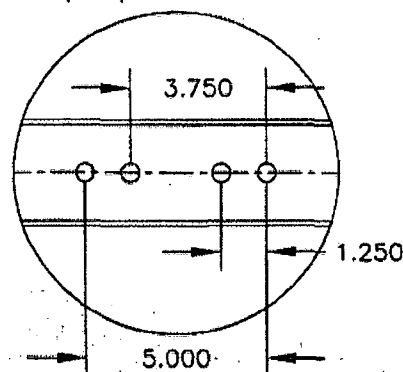
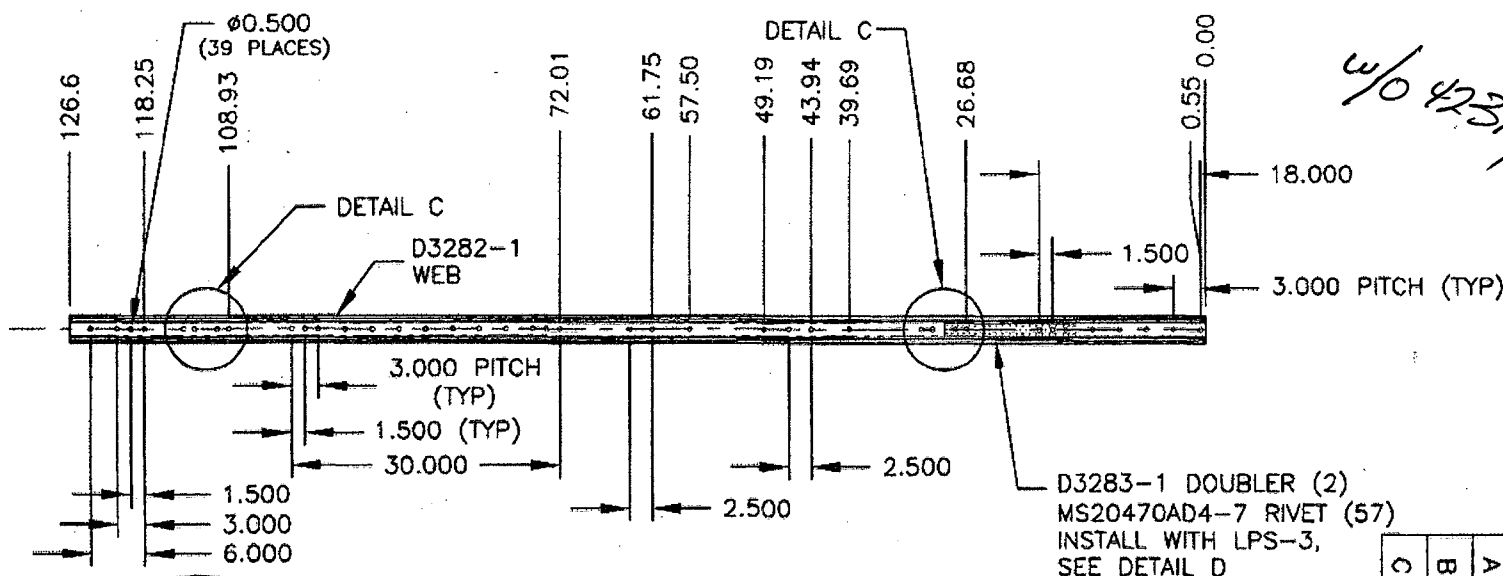
- 1 UNIFORM SECTION A-A
- 2 UNIFORM TAPER FROM SECTION A-A TO SECTION B-B
- 3 UNIFORM SECTION B-B
- 4 UNIFORM TAPER FROM SECTION B-B TO SECTION A-A
- 5 DRILL #30 (Ø0.128 REF) HOLES (57 PLACES) TO LINE UP WITH D3283-1, SEE DETAIL D FOR REFERENCE
- 6 UNIFORM SECTION A-A
- 6 R1.00 BETWEEN SECTIONS



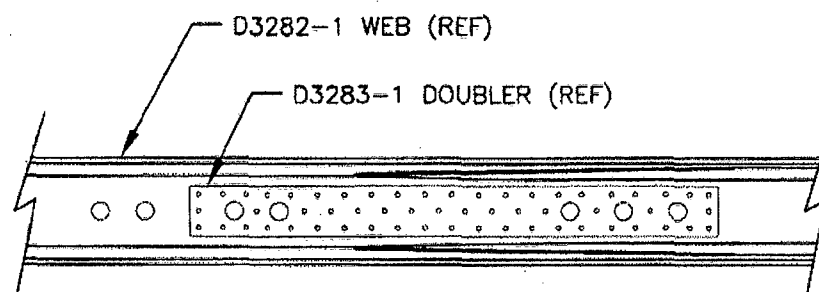
RELEASED
05-01-12



DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CP	CP	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
#	#	D3282
DATE		TITLE
05.08.09		Float WEB, 206L/407
		SCALE
		1:20
A	04.05.05	NEW ISSUE
B	05.03.16	MOVE HOLES, ADD D3390-1 DOUBLERS
C	05.08.09	REMOVE D3390-1, NOW MACHINED



DETAIL C
SCALE 1:5
RIVET HOLES NOT SHOWN
FOR CLARITY



DETAIL D
SCALE 1:5

D3282-041 FLOAT WEB

- 1) MAKE FROM D2792-130 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) APPLY A LAYER OF LPS LABORATORIES' LPS-3 BETWEEN D3283-1 DOUBLERS AND D3282-1 WEB. INSTALL RIVETS COATED WITH LPS-3
- 6) SEE PAGE 2 FOR MACHINING DETAILS

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RELEASED
05.09.12

DART AEROSPACE LTD		Work Order:	42314
Description: Float Web		Part Number:	D3282-041
Inspection Dwg: D3282 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
126.6	+/-0.100	126.660	✓			
1.500	+/-0.010	1.500	✓			
3.000	+/-0.010	3.000	✓			
6.000	+/-0.010	6.000	✓			
1.250	+/-0.010	1.250	✓			
30.000	+/-0.010	30.000	✓			
1.500	+/-0.010	1.500	✓			
72.01	+/-0.030	72.010	✓			
61.75	+/-0.030	61.750	✓			
57.50	+/-0.030	57.500	✓			
49.19	+/-0.030	49.190	✓			
43.94	+/-0.030	43.940	✓			
39.69	+/-0.030	39.690	✓			
26.68	+/-0.030	26.680	✓			
0.55	+/-0.030	0.550	✓			
1.970	+/-0.010	1.970	✓			
2.38	+/-0.030	2.378	✓			
0.05	+/-0.030	0.050	✓			

Measured by:	<i>[Signature]</i>	Audited by:	J.L	Prototype Approval:	N/A
Date:	08/09/29	Date:	08/10/01	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.04.02	New Issue	KJ/JLM <i>[Signature]</i>	<i>[Signature]</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3282-041 PAR #: N/A Fault Category: Prod / Machine Parts NCR: (Yes) No DQA: D Date: 08/18/16
 Resolution: D306-642-541/SP Disposition: _____ QA: N/C Closed: D Date: 08/18/16

NCR: <u>42314</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08-10-01	4.0	It was noticed upon inspection a huge mark in the web 32" from the aft, 0.030" deep. R.C: Possible damage from stacking, and hitting it with another web.		SCRAP: No replace. set up already tore down on the HAAS.	<u>J.L.</u> 08/09/01	<u>J.L.</u> 08/10/01		
08/10/01	4.0.	One web is mark by drill chuck, 0.020" DEEP CIRCULAR DENT & Ø1.375. R.C. operator error		SCRAP TUBE. DMG IN MIDDLE SPAN OF TUBE. MAT'L LOOKS STRETCHED. 08.09.01	<u>J.L.</u> 08/09/01	<u>J.L.</u> 08/10/01		

NOTE: Date & initial all entries